

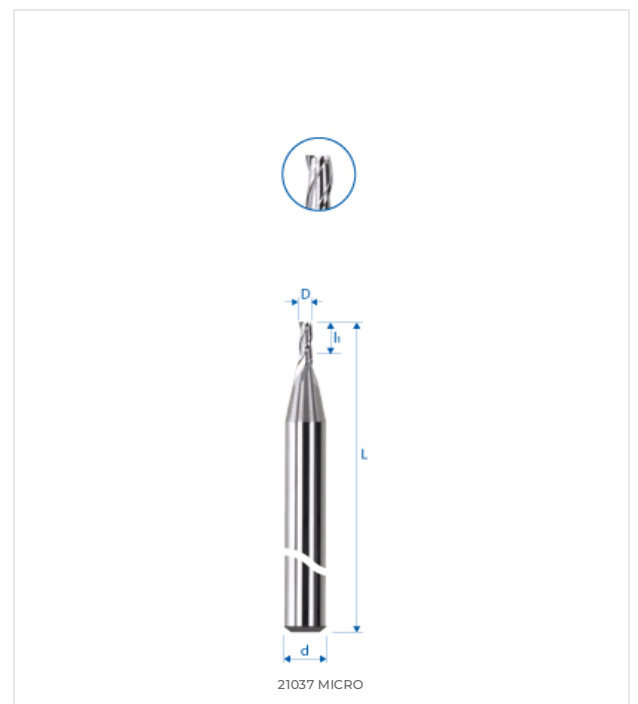
CARBIDE TOOL MATERIAL E25 UF	CUTTING ANGLES $\lambda=30^{\circ}\text{-}35^{\circ}$ $\gamma=8^{\circ}$	ACUTE ANGLE PRECISION TOOL	DUAL DIRECTION HELICAL DRILL BIT	2.2xD DEPTH FOR TOOLS	STANDARD TOOL WEAR INDICATOR	ADJUSTABLE ANGLE ICON	VARIABLE HELIX DRILL BIT
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MATERIAL COMPATIBILITY

●●● Excellent (3/3) ●● Good (2/3) ●○ Possible (1/3) ○○○ Not recommended

MATERIAL	SPECIFICATION	GRP	21037-1.8
Alloyed and non-alloyed steels <small>Non-alloyed steels</small>	Rm < 450 N/mm ²	1a	●○
	Rm 450–700 N/mm ²	1b	○○
	Rm 700–900 N/mm ²	1c	○○
	Rm > 1200 N/mm ²	1d	○○
Stainless steels <small>Stainless steels</small>	Rm < 650 N/mm ²	2a	○○
	Rm 650–950 N/mm ²	2b	○○
	Rm > 950 N/mm ²	2c	○○
Hardened steels <small>Hardened steels</small>	44–56 HRC	3a	○○
	57–67 HRC	3b	○○
Exotic materials <small>Special alloys</small>	< 32 HRC	4a	○○
	> 32 HRC	4b	○○
Graphite <small>Industrial graphite</small>		5	●○
Cast iron <small>Grey / nodular cast iron</small>	< 32 HRC	6a	○○
	> 32 HRC	6b	○○
Titanium <small>Titanium alloys</small>	Rm < 600 N/mm ²	7a	●○
	600 < Rm N/mm ²	7b	●○
Nickel alloys <small>Inconel, Hastelloy</small>	Rm < 1000 N/mm ²	8a	○○
	Rm > 1000 N/mm ²	8b	○○
Copper, brass, bronze <small>Copper-based</small>	Rm < 850 N/mm ²	9a	●●●
	Rm > 850 N/mm ²	9b	●●●
Aluminum <small>Aluminum alloys</small>	Si < 0.5%	10a	●●○
	0.5% < Si < 5%	10b	●●○
	Si > 5%	10c	○○
Synthetic materials <small>Engineering plastics</small>	Thermoplastic	11a	●●●
	Thermoset	11b	●●●
Composite materials <small>Reinforced composites</small>	Glass fiber / GFK	12a	●○
	Carbon fiber / KFK	12b	●○
Precious metals <small>Gold, platinum, silver</small>	Gold	13a	●●●
	Platinum	13b	○○

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS	
D (0 / -0.01)	1.8 mm
d (h5)	3 mm
L	38 mm
l1	4 mm
l3	–
d3	–
R	–
e	–
Z	3
Chamfer K	–
w° collision	5.5°

